

Date: Wednesday, 11/30/2005 8:14:24 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING LUG
Job Number : 25027	
Estimate Number : 10817	
P.O. Number : N/A	Part Number : D31753
This Issue : 11/30/2005 S.O. No. : N/A	Drawing Number : D3175 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 25027	Material : N/A
Written By : <u>See comment below</u>	Due Date : 12/7/2005 Qty: 30 Um: Each
Checked & Approved By : <u>See comment below</u>	
Comment : Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0375X01250	6061-T6 Bar .375 x 1.25"
		<i>used 3" mat.</i>
Comment: Qty.: 0.1860 f(s)/Unit Total : 5.5787 f(s) Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11) 0.375" thick (M6061T6B0.375x01.250) Batch: <u>M17887</u>		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks: 2.125" x 1.250"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA294 and Dwg D3175 Deburr and Tumble Identify as D3175-3		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		

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Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD / 12/11/05 / 30

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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205.12.12

Comment: INSPECT CHEMICAL CONVERSION COAT

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 402

C205/12/12 (30)

9.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

545 25/12/13

(30)

205/12/13

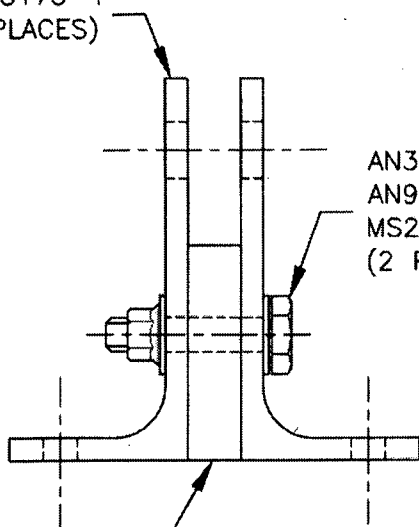
Job Completion



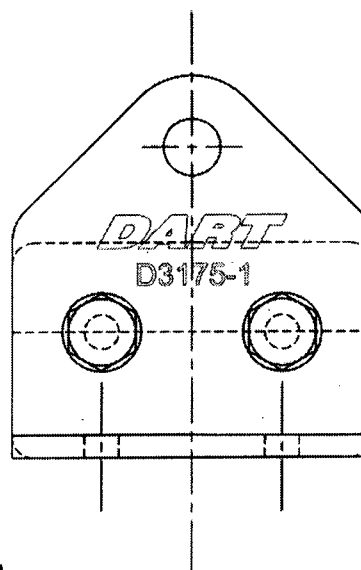


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3175	REV. A SHEET 1 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1
A	02.12.03	NEW ISSUE	

D3175-1
(2 PLACES)



AN3-7A BOLT (1)
AN960JD10L WASHER (2)
MS21042L3 NUT (1)
(2 PLACES)

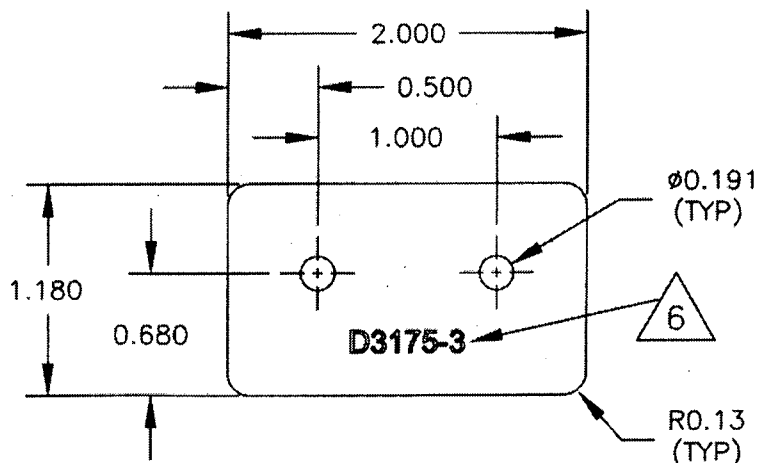


D3175-3

D3175-041 MOUNTING LUG

FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1)
PER DART QSI 005 4.3

RELEASED
02.12.03 *#*



D3175-3 SPACER

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.285 TO 0.290 THICK
(QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

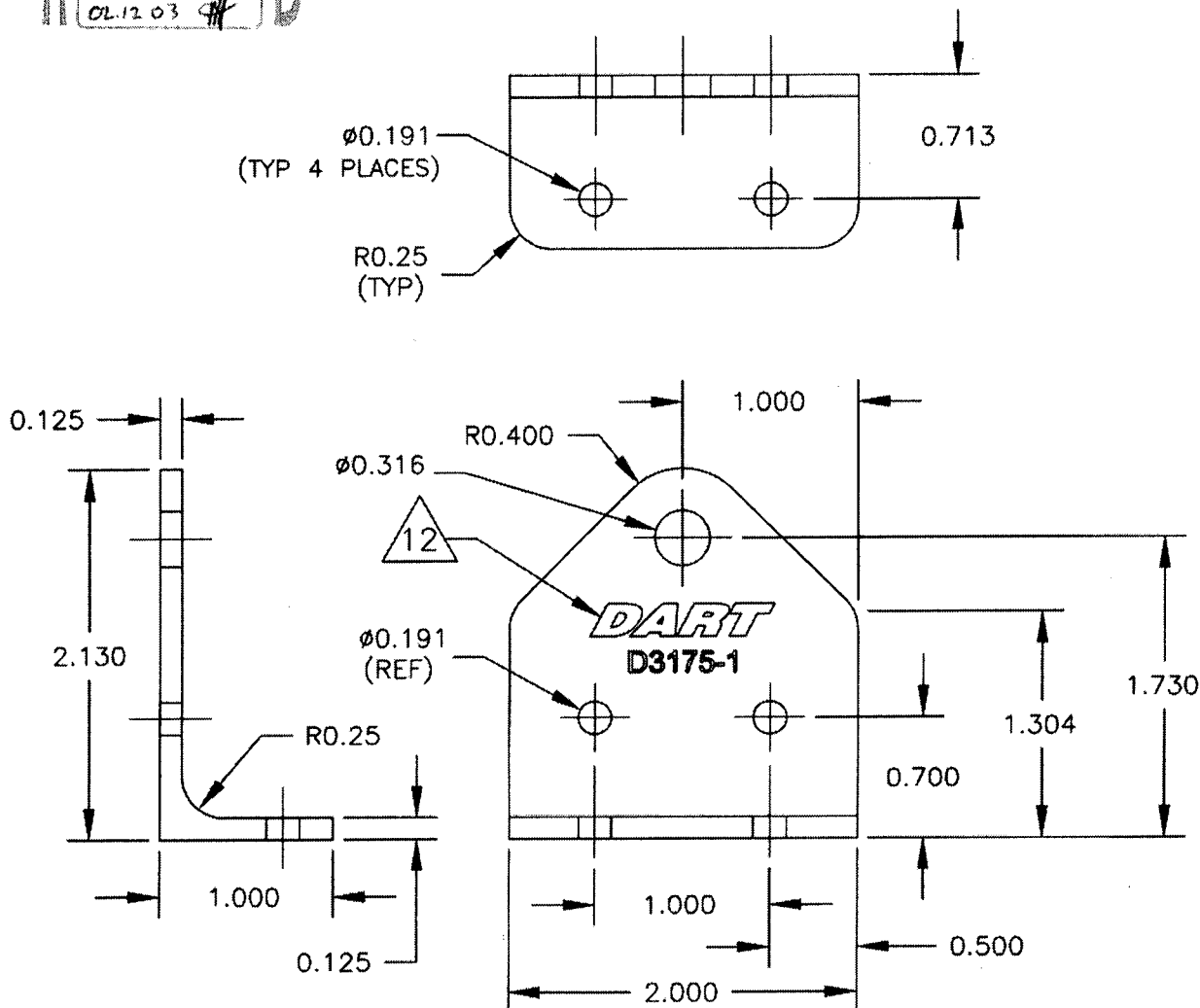
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3175	REV. A SHEET 2 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
02.12.03 #



D3175-1 BRACKET

- 7) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 9) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) ENGRAVE DART LOGO & P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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